

Date: Wednesday, 6/6/2007 3:04:21 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE BRACKET (206I)
Job Number	: 32820		
Estimate Number	: 11007		
P.O. Number	: N/A	Part Number	: D2607
This Issue	: 6/6/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2607 REV A1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25473	Drawing Revision	: A1
		Material	: N/A
Written By	: <u>LA 07.06.07</u>	Due Date	: 6/30/2007
Checked & Approved By	: <u>LA 07.06.07</u>	Qty:	<u>30</u> Um: Each
Comment	: Est. E 02.06.05 Added alodine finish TSR 1290 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------

water st



Comment: Qty.: 0.1313 sf(s)/Unit Total: 0.7875 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 Stack of 10
 (M2024T3S.040) Batch M105225 B 07-09-21

(35)

2.0	SHEAR	SHEAR
-----	------------------	------------------

water st



Comment: ~~SHEAR~~
~~Cut Blanks 1.891 X 9.03 (Grain along 9.03, offset 10°)~~ B 07-09-21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: ~~HAAS CNC VERTICAL MACHINING #1~~
~~Machine per folio D2607~~ N/A

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE B 07-09-21

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK B 07-09-21 caution

B 07-09-21 caution (35)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 2/1/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:04:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET (2061)

Job Number: 32820

Part Number: D2607

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2607

SB 07/11/07 (35)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/11/07 (35) counted

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD 07/11/08 (35) counted

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 42

(overstock) 07/11/08

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/08 (35)

Job Completion



U 07.11.08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

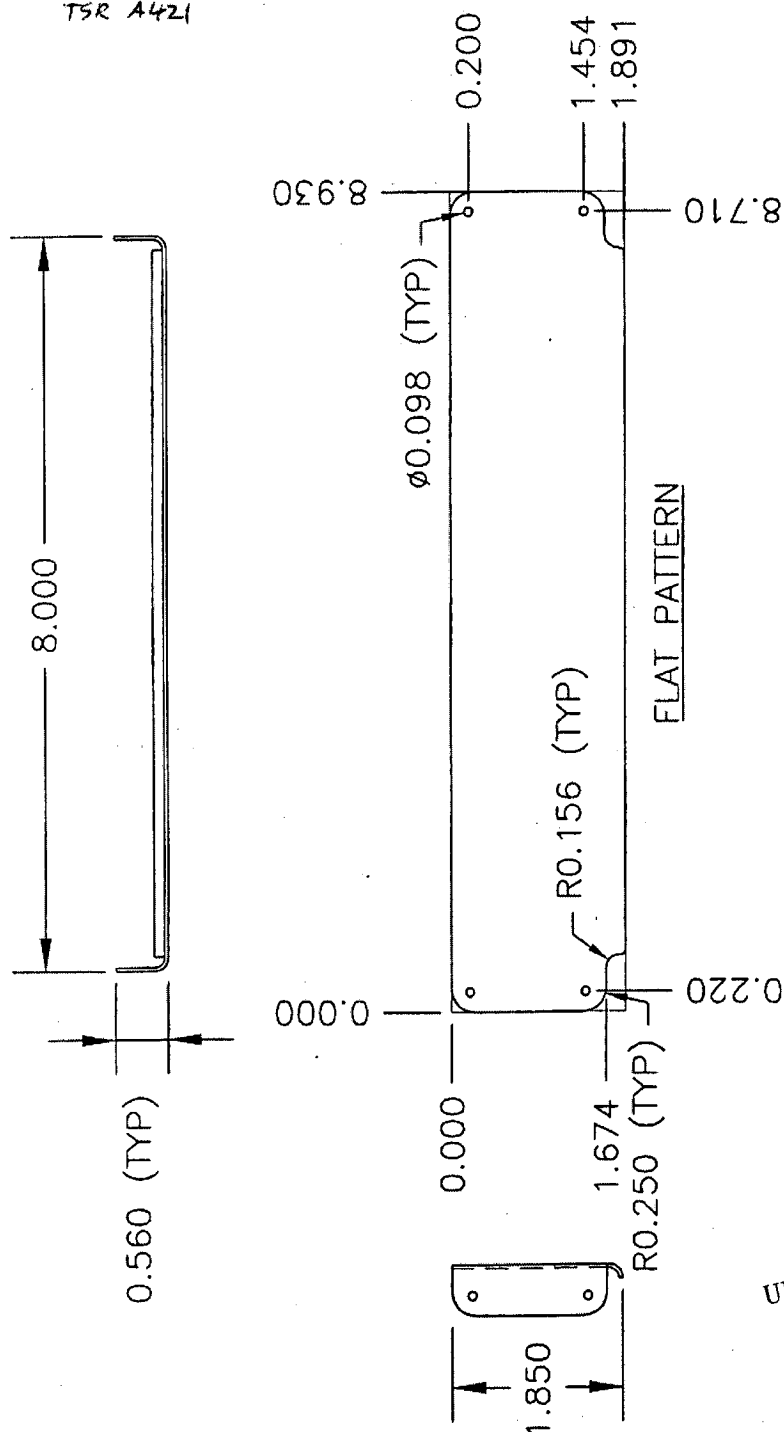
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2607	REV. A SHEET 1 OF 1
DATE 97.10.23		TITLE CONSOLE BRACKET	SCALE 1:2
A	97.10.23	D2607 WAS D206-547-9	
AI	<i>AI</i> 02.06.04	ADD FINISH	

RELEASED
97.11.04 KE
TSR A421



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **32820**

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2607
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 **AI**